

Work Order ID 73168

Friday, August 26, 2011 7:14:54 AM



Page 1

Item ID: D3641-1

Accept



Setup Start



Revision ID:

Item Name: Cover

Stop



Start Date: 8/26/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/08/26

Tooling:

Date:

Run Start



QC: _____ Date: _____

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3641	Rev C

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3641

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

Sos2.037

B11-9-1

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-9-1

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 409101

(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73168

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Page 2

Item ID: D3641-1

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Revision ID:

Stop



Item Name: Cover

Start Date: 8/26/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3641-1	0.00 0.00				<u>10</u>			
			SB 11/09/27						
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>10</u>			
			D. L. L. 11/09/27						
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>10</u> counted			11/09/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73168

Friday, August 26, 2011 7:14:54 AM



Page 3

Item ID: D3641-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 8/26/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 BL 11-9-27.

170

Identify as per dwg & Stock Location: *St 2600*

0.00



Packaging

Memo

0.00

Packaging

10x 11-09-28

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/28

ME 11-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:14:51 AM

Page 1

Work Order ID: 73168

Parent Item: D3641-1

Parent Item Name: Cover





Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	98.3000	0.7987	6.725895	8.		
													
										 B 11-9-1			
5052-H32 .032 Sheet													

B 11-9-1

Location	Loc Qty	Loc Code
MAT022	98.3	
100470	2	
103321	2	
105998	3	
108462	5	
109478	6	
111448	2	
112664	16	
115638	12	
116657	27	
117798	23.3	

112664 7x = 5.6
117798 3x = 2.4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73168
Description: Cover		Part Number:	D3641-1
Inspection Dwg: D3641 Rev: B		Page 1 of 1	

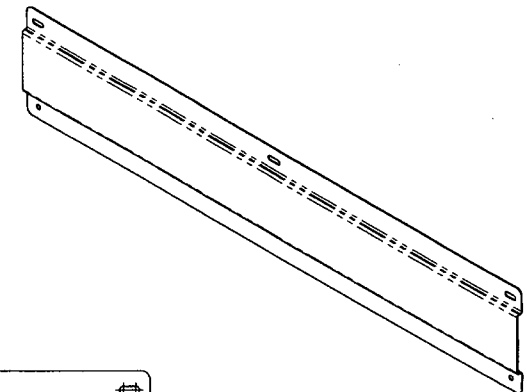
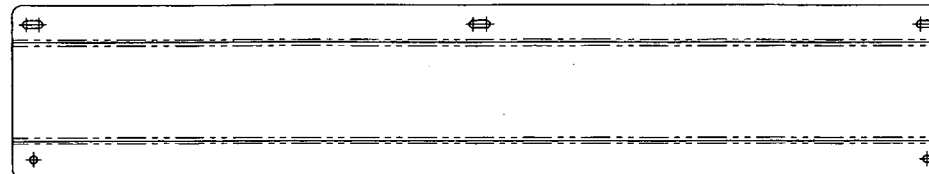
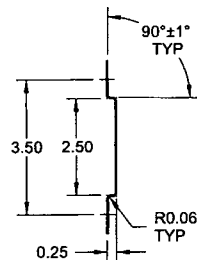
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	.194	X		✓ HB02	
0.191	+/-0.010	.193	✓		✓	
0.37	+/-0.030	.37	✓		✓	
0.54	+/-0.030	.54	✓		✓	
0.69	+/-0.030	.69	✓		✓	
11.86	+/-0.030	11.86	✓		✓ HB01	
12.22	+/-0.030	12.22	✓		✓	
23.37	+/-0.030	23.37	✓		✓	
23.54	+/-0.030	23.54	✓		✓	
23.69	+/-0.030	23.69	✓		✓	
24.06	+/-0.030	24.06	✓		✓	
0.50	+/-0.030	.502	✓		✓	
4.28	+/-0.030	4.281	✓		✓	
4.78	+/-0.030	4.786	✓		✓	
0.032	+/-0.010	.035	✓		✓	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-9-1	Date: 11/09/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	



D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)
 (MAKE FROM D3641-1F FLAT PATTERN)

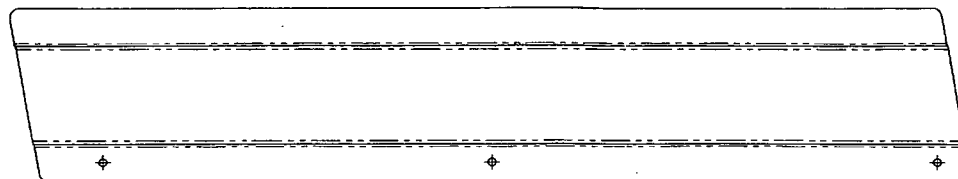
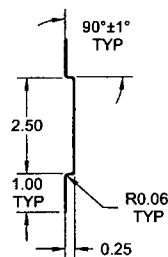
RELEASED
 2009-11-18

NOTES:

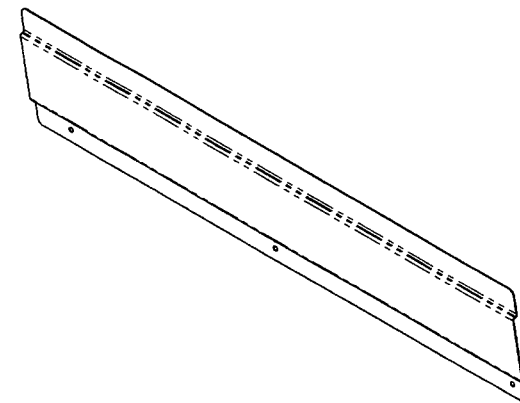
- 1) MATERIAL: D3641-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 73168

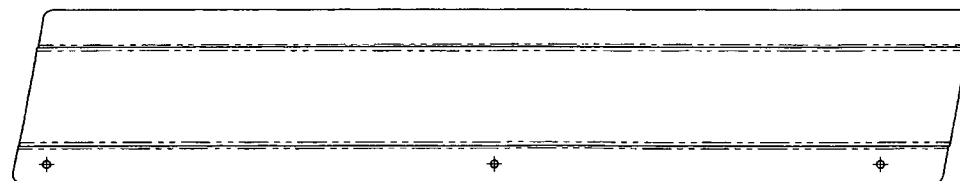
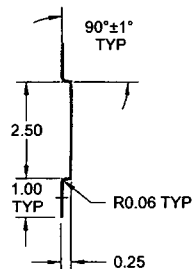
C	REFORMAT DRAWING TO CURRENT STANDARDS; D3641-3 WAS -4 (ZN C4-2); ADD D3641-4 VIEW (ZN A4-2); MOVE -1F/-3F FLAT PATTERN TO SHEET 3. PER NCR 09-076	RF	09.10.02
B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	09.10.02	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
(MAKE FROM D3641-3F FLAT PATTERN)



D3641-3 COVER (SHOWN)
D3641-4 COVER (OPPOSITE)



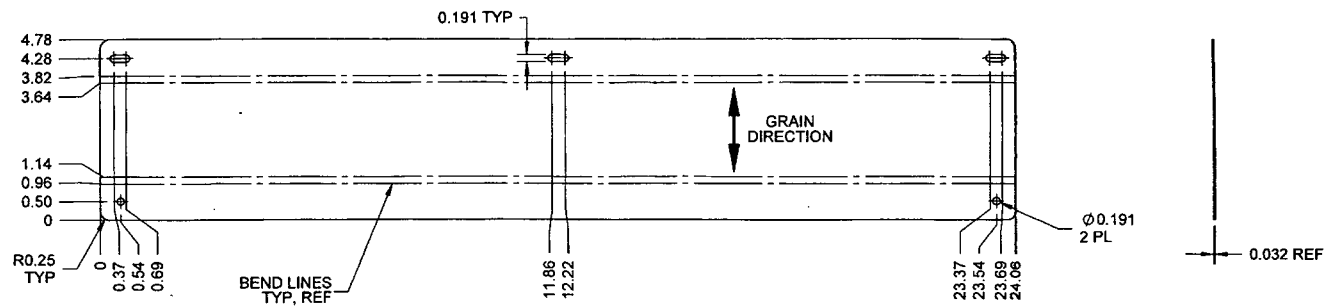
D3641-4 COVER
(REPLACES GENEVA P/N G10606-4)
(MAKE FROM D3641-3F FLAT PATTERN)

RELEASED
2009-11-10

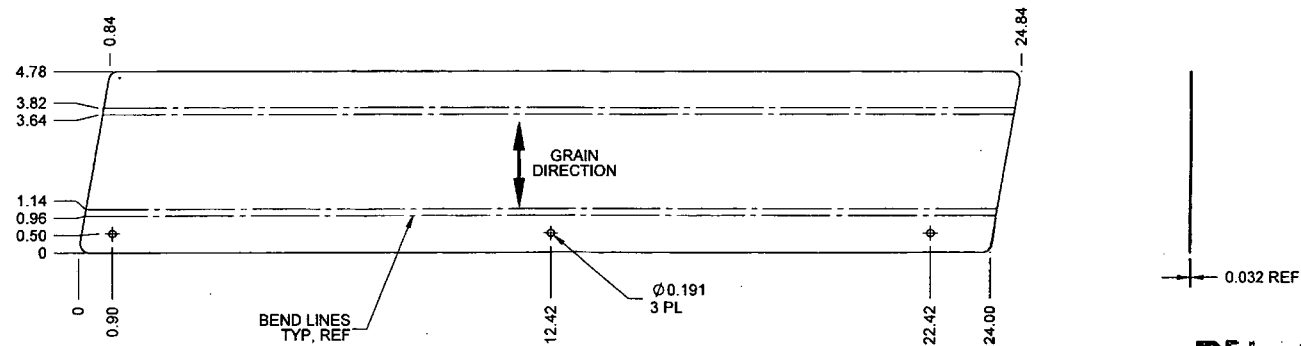
NOTES:

- 1) MATERIAL: D3641-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
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D3641-1F FLAT PATTERN



D3641-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1F/-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
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2009 -11- 10